

PATENT ABSTRACTS OF JAPAN

(11)Publication number : 10-289632

(43)Date of publication of application : 27.10.1998

(51)Int.Cl. H01H 13/14
B29D 31/00
H01H 11/00
H01H 13/48
// B29K101:12

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(54) SHEET KEY TOP AND ITS MANUFACTURE

(57)Abstract:

PROBLEM TO BE SOLVED: To improve clicking sensation and prevent contact parts from being damaged by residual stress by providing a gate injection port of a thermoplastic material in a side part of a pressing element or a side thrusting element formed in a metal mold so as to perform injection and setting the tip shape of the pressing element of a pushbutton switch for pushing a bent contact part such as a metal disc spring into a spherical shape.

SOLUTION: A film 1 having a print surface 6 on which a display part is printed

beforehand is set in a metal mold having a pressing element 2 whose tip shape is spherical and a thermoplastic material 3 is injected and molded after closing so as to be integrally molded with the film 7. In this case, a gate injection port 8 is provided in the side part of the pressing element 2 having the spherical tip or a side thrusting element part 5 formed in a metal mold and the thermoplastic material 3 is injected therein so that the tip shape of the pressing element 2 is formed into a spherical



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shape. The lives of the contact parts of the metal disc spring, the resin film dome, etc., are thus elongated by forming the tip part of the pressing element 2 into the spherical shape and the positioning process of the sheet key top and the contact parts can be facilitated thereby.

LEGAL STATUS

[Date of request for examination] 08.04.2004

[Date of sending the examiner's
decision of rejection]

[Kind of final disposal of application
other than the examiner's decision
of rejection or application
converted registration]

[Date of final disposal for
application]

[Patent number]

[Date of registration]

[Number of appeal against
examiner's decision of rejection]

[Date of requesting appeal against
examiner's decision of rejection]

[Date of extinction of right]

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